DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1x.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-022026
Date Inspected: 17-Mar-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 830
OSM Departure Time: 1500
Location: Job Site

CWI Name: Gary Ehrsam

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:
This Quality Assurance Inspector (QAI) was present at the Self Anchored Suspension (SAS) job site. The following items were observed; see individual item numbers in the body of this report for further details.

Field Splice 5W/6W
1, Longitudinal Stiffeners. SMAW welding in process.

Field Splice 6W/7W
2, Longitudinal Stiffeners. SMAW welding in process.

1, Field Splice 5W/6W
The QAI periodically observed AB/F approved welder Xiao Jian Wan, ID - 9677 welding longitudinal stiffener LS-2 utilizing the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical up) position with AWS E-9018 filler metal per ABF – WPS - D15 - 1012-3. AB/F QC Inspector Gary Ehrsam was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF – WPS - D15 - 1012-3. After welding of side one and back gouging side two, the QC Gary Ehrsam performed Magnetic Particle Testing (MT) of the back gouge prior to Mr. Wan welding side two. Mr. Ersam reported that no relevant indications were observed. The QAI observed that the performance and evaluation of the welding appeared to comply with the approved welding quality control plan and MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work was not completed at this location during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

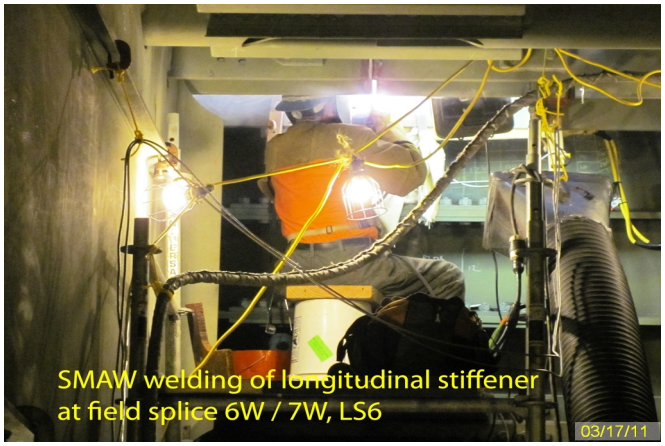
The QAI periodically observed AB/F approved welder Wai Kit Lai, ID – 2953 welding longitudinal stiffener LS-5 utilizing the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical up) position with AWS E-9018 filler metal per ABF – WPS - D15 - 1012-3. AB/F QC Inspector Gary Ehrsam was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF – WPS - D15 - 1012-3. After welding of side one and back gouging side two, the QAI observed QC Gary Ehrsam performing Magnetic Particle Testing (MT) of the back gouge prior to Mr. Lai welding side two. Mr. Ersam reported that no relevant indications were observed. The QAI observed that the performance and evaluation of the welding appeared to comply with the approved welding quality control plan and MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work was completed on stiffener LS-5 during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

Welding was then started on stiffener LS-4 after QC Gary Ersam accepted the fit up and weld joint was preheated per WPS requirements. The QAI observed that stiffener LS-4 contained offset of 2mm at the top edge to 2.5mm at the bottom edge, which meets the minimum requirement of AWS D1.5-2002 section 3. Work was not completed at this location during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

2, Field Splice 6W/7W

The QAI periodically observed AB/F approved welder Jin Pei Wang, ID – 7299 welding longitudinal stiffener LS-6 utilizing the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical up) position with AWS E-9018 filler metal per ABF – WPS - D15 – 1012-3. AB/F QC Inspector Gary Ehrsam was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF – WPS - D15 - 1012-3. After welding was complete, the QAI observed QC Gary Ehrsam performing a preliminary visual inspection. Mr. Ersam reported that the weld appeared to meet contract requirements. The QAI observed that the performance and evaluation of the welding appeared to comply with the approved welding quality control plan. Work was completed on stiffener LS-5 during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

Welding was then started on stiffener LS-5 after QC Gary Ersam accepted the fit up and weld joint was preheated per WPS requirements. Work was not completed at this location during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

General conversations with QC personnel regarding welding locations and schedule. And as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer